

Date: Tuesday, 11/21/2006 10:49:08 AM  
User: Kim Johnston

## Process Sheet

Dart Aerospace Ltd.

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 29559  
Estimate Number : 12538  
P.O. Number : N/A  
This Issue : 11/21/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL / MED FAB  
Previous Run : 28797

Drawing Name : BRACKET

Part Number : D35461  
Drawing Number : D3546 REV A  
Project Number : N/A  
Drawing Revision : A  
Material : N/A  
Due Date : 11/23/2006

Qty: 20 Um: Each

Written By :  
Checked & Approved By :  
Comment : Est Rev: New Issue 06-09-27 JLM

### Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 M304S186A 6061 T6-080 Sheet

Comment: Qty.: 0.2205 sf(s)/Unit Total: 4.4100 sf(s)

6061-T6 aluminum sheet 080 Sheet

Batch: M120997

ml 06 11 21

(20)

2.0 WATER JET FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3546

Dwg Rev: A

Prog Rev: A

ml 06 11 21

(20)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE

Comment: NC BRAKE

Form as per Dwg D3546

SB 06/11/21

(17)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 10:49:08 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29559

Part Number: D35461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AD 06/11/23 (17)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 11 21 (17)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PV 4/4/27 (17)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PV 4/4/27 (17)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

17  
LB 06/11/08

Job Completion



C206/11/28





→  
PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

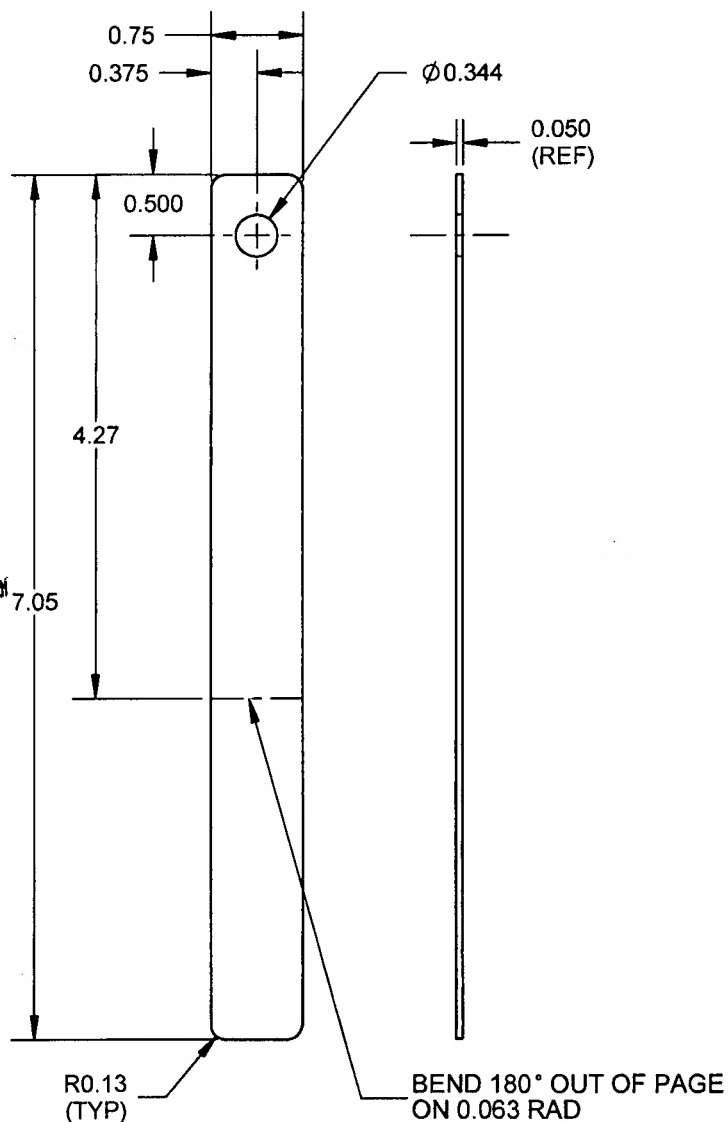
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

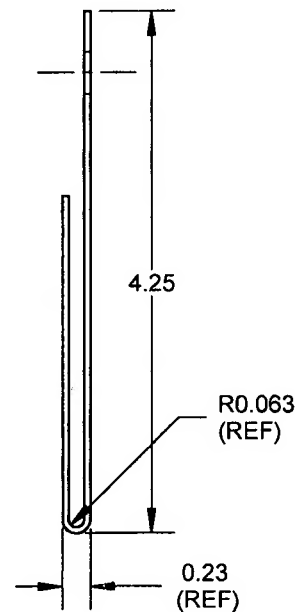
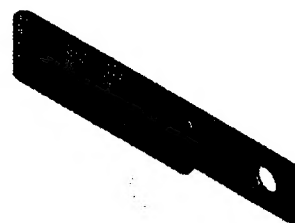
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/23	5	3 piece out of tolerance		Scrap & destroy (Made a tool for bending)	SB 06/11/23	 06/11/23		 06/11/23

NOTE: Date & initial all entries

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>gp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3546</b>	REV. A SHEET 1 OF 1
DATE <b>06.09.15</b>	TITLE <b>CLIP</b> SCALE 1:1		
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	



**D3546-1F FLAT PATTERN**



**D3546-1 CLIP**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29559

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